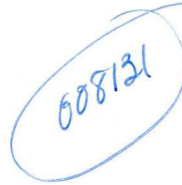




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



647.7401
Job Sheet 190161



Part No: 647.7401

Job Qty: 1 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 4/1/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/1/19		0.00	0.00	Packaging 1 - 1		FEB 14 2019
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
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							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

Plex 2/5/19 1:00 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) ☐	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Plex 2/5/19 1:00 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	1 pcs	4/1/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-88 FEB 26 2019

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE

598: _____ exp. date: _____

130 - QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015 102	Blade	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5105905
647.7610 102	Upper Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5129080
647.7810 102	Bracket A	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5115701
647.7811 102	Bracket B	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5114688
647.7812 102	Center Plate, Upper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5032493
MS21042-3	Nut use MS21042L3 per QSI 017	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5134220
MS21042L08	Nut	13 Ea (13 ea)	110-Packaging 1 - Pick Kit	5080644
MS27039-08-19	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5104359
MS27039-08-23	Screw	7 Ea (7 ea)	110-Packaging 1 - Pick Kit	5031848
MS27039-1-19	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5133205
NAS1149F0332P	Washer	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5134693
NAS1149FN832P	Washer	68 Ea (68 ea)	110-Packaging 1 - Pick Kit	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3015	2	61	0
	647.7610	1	9	0
	647.7810	1	38	0
	647.7811	1	39	0
	647.7812	1	1	0
	MS21042-3	3	217	0
	MS21042L08	13	1,217	0
	MS27039-08-19	6	836	0
	MS27039-08-23	7	8	0
	MS27039-1-19	3	219	0
	NAS1149F0332P	6	3,048	0
	NAS1149FN832P	68	3,162	0

DART
AEROSPACE

Container No: S153790



Part: 647.7401

Job No: 190161

Serial No/Batch: S153790

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

uld not be found.

Plex 2/5/19 1:00 PM dart.white.jesse

Date: 02/14/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
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